

Date: Tuesday, 16/12/2008 3:21:51 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206B AFT X-TUBE
Job Number : 44142	
Estimate Number : 12347	
P.O. Number :	Part Number : D206667201
This Issue : 16/12/2008 S.O. No. :	Drawing Number : D206-667-241 REVB
Print Rev. : NC	Project Number : N/A
First Issue : 11 Type : CROSSTUBES	Drawing Revision : B
Previous Run : 44141	Material :
Written By :	Due Date : 05/01/2009 Qty: 1 Um: Each
Checked & Approved By : <u>Julie Dawson 12.16</u>	
Comment : Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJJ/JLM Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:EC	

Additional Product



Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JLD 09/02/02

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-201 CHG003

5 08/03/31

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

3.0	D206667201TRN	Crosstube Turning Detail
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch *15-41780*

MB 08-12-22

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------

**Comment:** BENDING MACHINE

Bend tube as per Dwg D206-667-241 using CNC bender program 206B-AF and Folio FT

MB 08-12-22

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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**Comment:** DIMENSIONAL CHECK OF X-TUBES

08-12-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206B AFT X-TUBE

Job Number: 44142

Part Number: D206667201

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

2-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576.
(DRILL 3 HOLES ON BOTH SIDES)

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate tube using "T" pins off holes drilled in previous step.

4-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

5-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576. Check dimensions between holes on all four sides to ensure proper alignment. Use DT8583 & 8584 SUPPORT Jigs.
(DRILL 3 HOLES ON BOTH SIDES)

6-Drill rivet holes as per Dwg D206-667-241 using drill Jig DT8788

7-C'sink holes as per Dwg D206-667-241

8-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241

9-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-241
Inside of Cuff (Do not engrave on outside of tube)

MB
08-12-22

MB
08-12-23

MB
08-12-22

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



MB
08-12-23



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MB
08-12-23



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 QC5

INSPECT WORK TO CURRENT STEP



MB
08-12-23



Comment: INSPECT WORK TO CURRENT STEP

PIC

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D206-667-201 PAR #: N/A Fault Category: Prod/x-tube NCR: (Yes) No DQA: D Date: 09/04/07
 Resolution: re-work Disposition: re-work QA: N/C Closed: D Date: 09/04/07

NCR: <u>44142</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-01-07	9.0	Rivet holes are not drilled as per dwg. DTB787 was used. This is for all other 206 x-tubes w/o is correct. R.c: Lack of attention by Employee & Inspector.	[Signature]	Modify 2x D2872-043 & -045 by filling the rivet holes with weld & grinding flush, per spec	[Signature]	See PTO on	[Signature]	09-01-07
	6.0			Touch-up with Alodine per spec				
			[Signature]	Bolt on to the x-tube into position & transfer drill the D2872-043 & -045 & deburr. Touch-up with Alodine as necessary.	Page 3		[Signature]	09-01-07
			[Signature]	rivet in to position after paint.	09-03-24	S	[Signature]	09-01-07
			[Signature]	Retrain & notify employee & inspector of this issue.	[Signature]	09/03/30	[Signature]	09-01-07

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Drawing Name: 206B AFT X-TUBE

Job Number: 44142

Part Number: D206667201

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	OUTSIDE SERV.11	OUTSIDE SERVICE -CROSSTUBES
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7/10:7923



Comment: Sub-Contracting OUTSIDE SERVICE -CROSSTUBES

02/09/10/108 ①

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

PC 9/10/7 ①

12.0	-Q66 Q65	DIMENSIONAL CHECK
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ml 09/10/08 ①



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

13.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

25 09-01-08

14.0	QC14	INSPECT SPRAY PAINT
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ml 09/10/09 ①



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

15.0	D3595075395	RUBBER CUSHION .75" x 3.95
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① Pts

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RUBBER CUSHION .75" x 3.95

batch: 37971

cut from
-750

25 09-01-09

16.0	D28911	2.25 Support
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support 38122

25 09-01-09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.02.09	22/ 23	PICK Qty(2) D3877-041 NUTPLATE B/N <u>45376</u> Qty(2) D3877-043 NUTPLATE B/N <u>45375</u>	AT	09-03-25		CP 09.02.09 per QSI 042	S 09/03/30	
09.02.09	23.1	INSTALL D3877-041/-043 WITH Qty(14) MS20601AD4W10 B/N <u>110219</u>	AT	09 03 25		CP 09.02.09 per QSI 042	S 09/03/30	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 44142

Part Number: D206667201

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 MS2192020 Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

109715

25 09-01-09

18.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

A/R Magnabond 6398 batch: 109900

1-Install supports and clamps as per Dwg D206-667-241 and DSI9415. Torque clamps to 80-100 in lb

25 07-01-09

19.0 QC5 INSPECT WORK TO CURRENT STEP



Ensure Pro 9.0 & 6.0 is completed



Comment: INSPECT WORK TO CURRENT STEP

8 09/03/30 (14)

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 AN532A Bolt



M110363



(14)

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

9/13/30

SG

22.0 D2872043 Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

SEE WYD CHG

Qty Part number Description Batch

2 D2872-043

Nut Plate

23.0 D2872045 Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

SEE WYD CHG

Qty Part number Description Batch

2 D2872-045

Nut Plate

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: 206B AFT X-TUBE

Job Number: 44142

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

10 AN5-10A

Description Batch

Bolt

M107013

M110363

EFFECTIVE 09.02.09

AUTH

RELEASED

DATE

09.03.24

PER 91N09-534

25.0

AN530A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

10 AN5-30A

Description Batch

Bolt

M109001

26.0

AN960JD516

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:Packing Kit

Qty Part number

20 AN960JD516

Description Batch

Washer

M110523

27.0

MS21042L5

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

10 MS21042L5

Description Batch

NUT

M110382

9/3/30

28.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-201

Location:

PPP Rev:

PPC

809/03/31

(VU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 206B AFT X-TUBE

Job Number: 44142

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/01 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

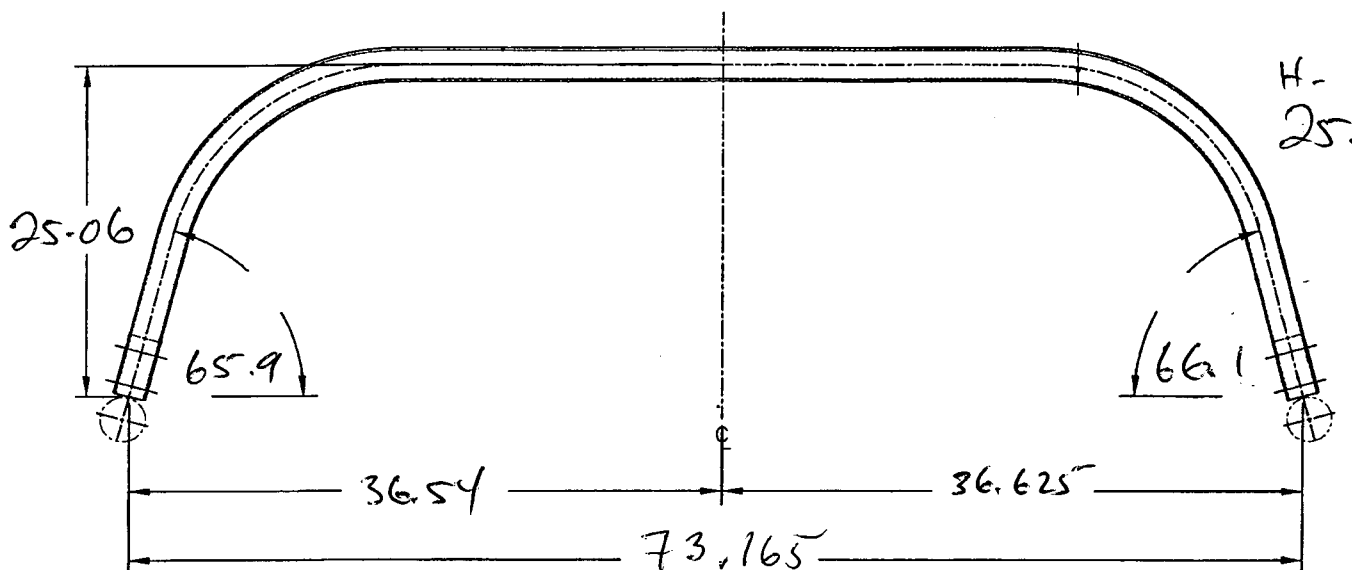
Job Completion



MF
09-03-31

DART AEROSPACE LTD		Work Order:	44142
Description: Crosstube High Aft (206B)		Part Number:	D206-667-201
Inspection Dwg: D206-667-241 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	24.98	25.10
1/2 Span	36.54	36.66
Angle	65	67
Total Span	73.08	73.32



Comments

QC15 Inspection	J 06.12.22
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	Jm
B	07.12.04	24-98 was 24.48	KJ/JM	

Item	Qty -241	Part Number	Description
1	X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
2	1	D6003-102	CROSSTUBE
3	2	D2891-1	SUPPORT
4	4	D3595-063-395	RUBBER CUSHION
5	4	MS21920-20	CLAMP (OR MS21920-21)
6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

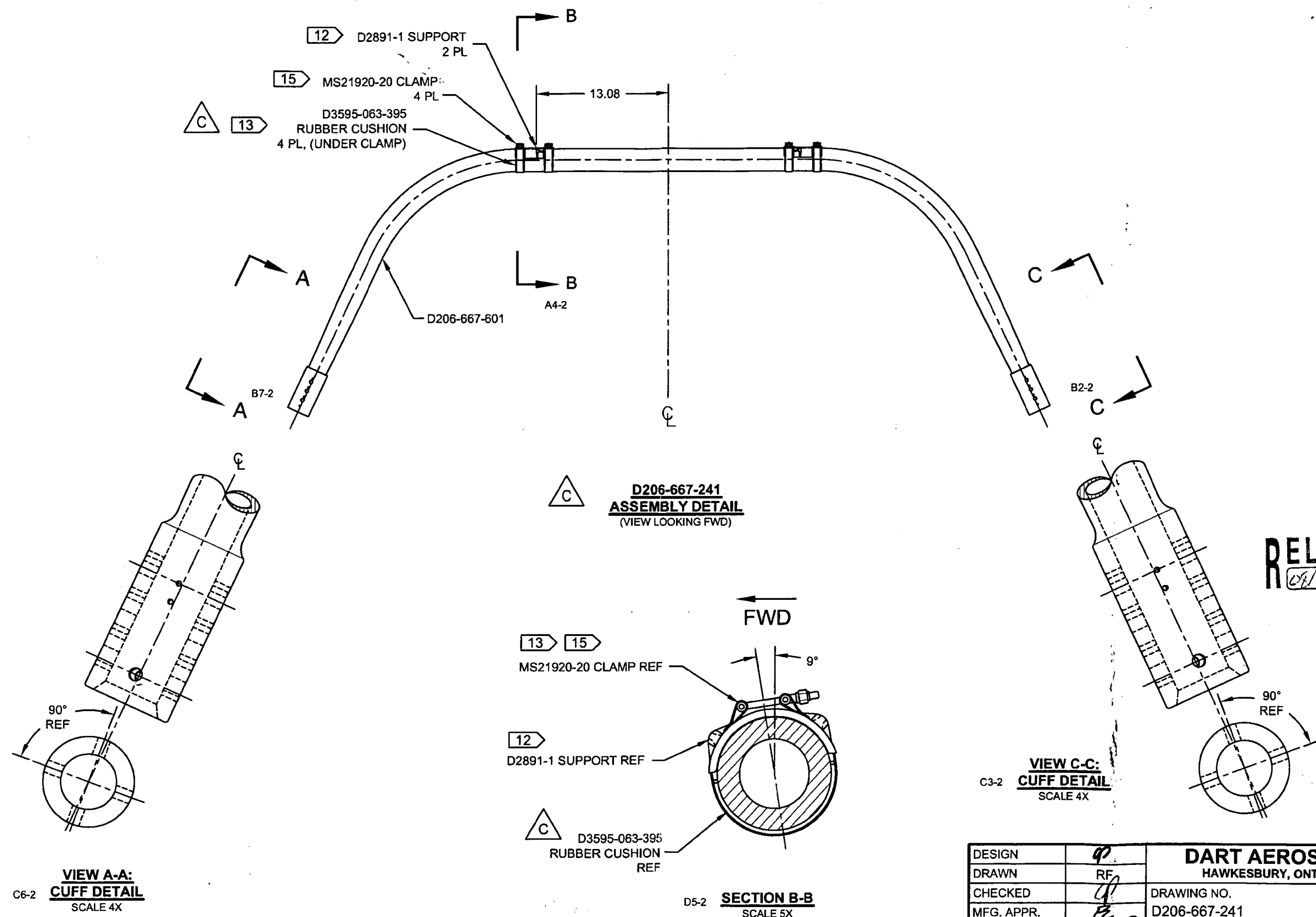
- 1) MATERIAL: MANUFACTURED FROM D6003-102
FINISHED LENGTH = 100.60±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-241" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 22.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS MECHANISMS ARE LOCATED ON CROSSTUBE CLAMPS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
08/11/12 MP

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C	REFORMAT/REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C5-3, C4-3, D3-3); RELOCATED FLAG #6 (ZN A7-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06 WORK ORDER 40142
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-241	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206B HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

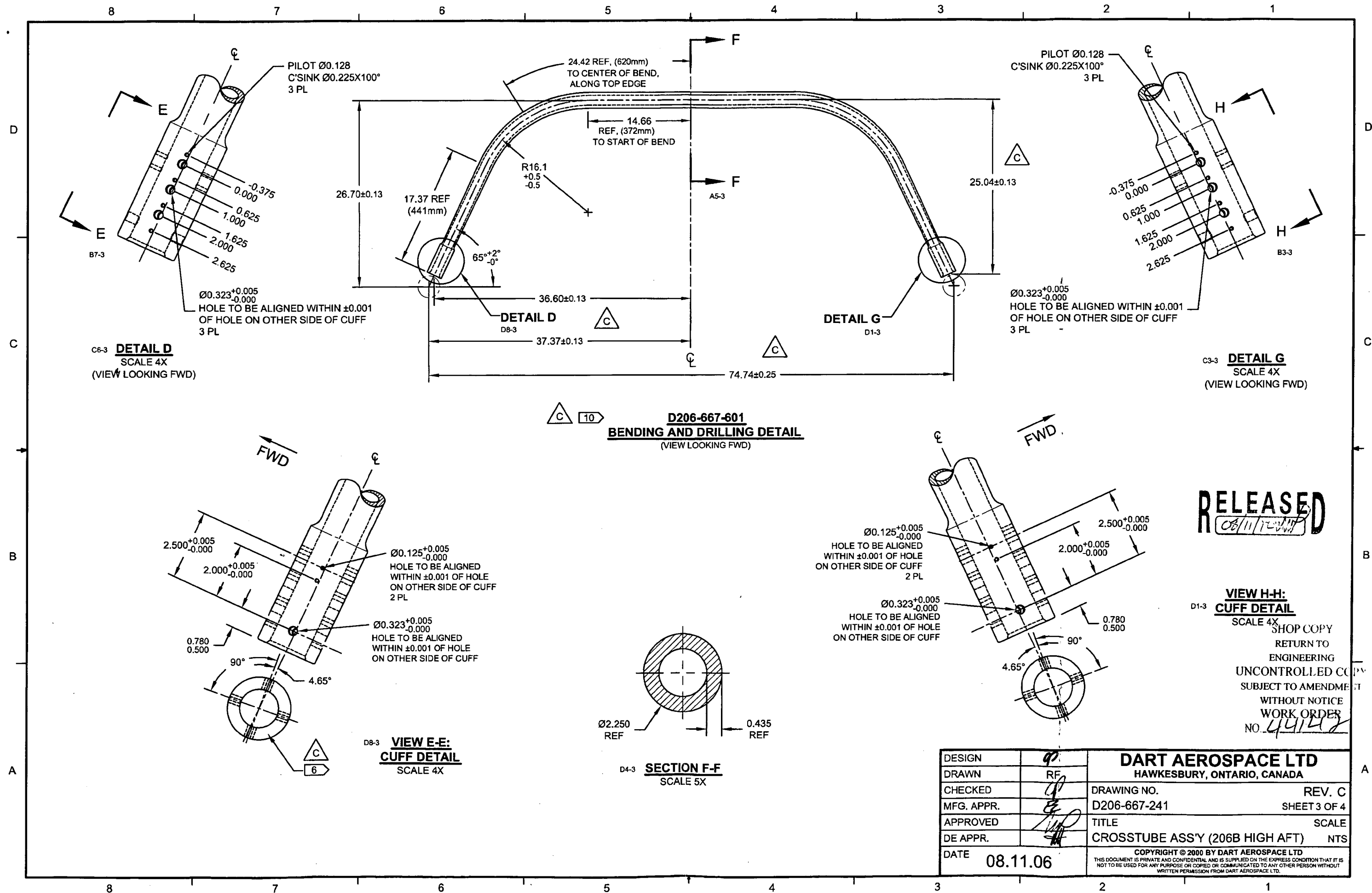
8 7 6 5 4 3 2 1



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08/11/12 M.D.

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WORK ORDER NO. 9414

DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. C
MFG. APPR.	9	D206-667-241	SHEET 2 OF 4
APPROVED	9	TITLE	SCALE
DE APPR.	9	CROSSTUBE ASS'Y (206B HIGH AFT)	NTS
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LIQUID PENETRANT TEST REPORT

P- 09135

PAGE 1 OF 1

Dart Aerospace
Linda Lacelle
1270 Aberdeen St.
Hawkesbury, Ont, K6A 1K4

DATE Sen 7, 2009 TIME AM ☐ PM ☐
ACUREN JOB NO. 188-08-1660
PO/WO No. 7923
WORK LOCATION Hawkesbury
ACCEPTANCE STD. ASTM 1417-021-038 REV./DATE 2005

PROJECT 206 BAFT X-TUBE, 206 FWD X-TUBE, 212/205 HIGH AFT X-TUBE ASSEMBLY
ITEM(S) EXAMINED Job #'s 44141, 44142, 44137, 44138, 44212, 44213

JOB DESCRIPTION PROCEDURE NO. LT-002 REV./DATE TECHNIQUE NO. LT-002 REV./DATE
PART NO. D206667201, D206667103B, D212664201 MATERIAL ALODINE ALUM. THICKNESS N/A
SCOPE WET FLOUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON
100% external surface

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNAPLUX BLACK LIGHT S/N B171 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT MINIMUM DWELL TIME 30 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H₂O MINIMUM DRY TIME >10 MIN. OTHER CAL F5809
DEVELOPER SK059 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

ITEM	COMMENTS	ACCEPT	REJECT
14137	Acceptable	✓	
14138		✓	
14141		✓	
14142		✓	
14212		✓	
14213		✓	

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.
Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Jan Titley PRINT SIGNATURE Jan Titley DTR #
TECHNICIAN (SIGNATURE): Frederick Chagnon 1ST TECHNICIAN 2ND TECHNICIAN
NAME (PRINT): CGSB LEVEL II SNT LEVEL II CGSB LEVEL II SNT LEVEL II
CGSB REG. No 10560 CGSB REG. No 10560

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CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY